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SUBTITUTE PAGES

An automated production monitoring system is known from US-A1-2003/102367, in which a transponder is used for transfer of delivered data for supply parts, which transponder is provided together with the supplied parts.

From DE-A1-197 51 517, for production of window frames it is known to provide the work piece with a transponder during the processing or treatment, in which transponder are contained data regarding the processing or treatment of the work piece.

A transponder-aided goods shipping system is known from DE-A1-199 53 622, in which goods are delivered to a goods container of a receiver that is secured with an access code. After ordering the good, the receiver programs a corresponding delivery code as an access code into the locking device of the goods container. Corresponding delivery code data of the good to be delivered are stored in the transponder. The transponder is read in order to be able to open the container and bin the good. The read and stored delivery codes must then coincide. As soon as the distributor has transferred the good into the container, a payment routine is initiated.

It is the object of the invention to optimally control the material flow in the production, the consumable part maintenance or the replacement part maintenance of products that are comprised of a plurality of individual parts, such that the production or, respectively, the operation of the products is interrupted as little as possible and occurs with verifiable quality.

This object is achieved via the invention specified in the independent claims. Advantageous embodiments of the invention are specified in the sub-claims.

According to a first aspect of the invention, in a method for controlling the material flow in the production , the consumable part maintenance or the replacement part maintenance of products that are comprised of a plurality of individual parts the

individual parts are respectively delivered to a goods receipt of a logistic system. At [sic] transponder is respectively associated with each individual part, in which transponder are stored production and/or delivery data regarding the individual part. The data of the transponder are read at the goods receipt and used for controlling the further material flow such that the individual parts are transported in a controlled manner to predetermined subsequent process stations.

Via the first aspect of the invention, relative to conventional systems in which deliveries of goods are documented with printed delivery receipts, that [sic] previously-used paper is replaced by electronic data exchange. The data exchange in particular occurs between a distributor of goods and a logistics organization that supplies the goods from one of the distributors to a buyer. The data exchange can, however, also occur directly between distributor and buyer or between all three participating parties. Corresponding computer systems and read or, respectively, write units of the distributor, logistic organization and buyer are networked with one another (for example via the Internet) for this.

According to a second aspect of the invention that can also be independent of the first aspect of the invention, a method for monitoring of the product quality of a